



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.7810
Job Sheet 178039



Part No: 647.7810

Job Qty: 6 ea

Part Name: Bracket A



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/25/18

Job Tracking No:

Due Date: 6/4/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev: A RQ 15.08.06 Verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		6/4/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	6 pcs		6/4/18	0.00	0.19	Bandsaw1		
110	CNC Vertical Machining	6 pcs		6/4/18	0.30	5.13	HAAS1-1		
120	QC	6 pcs		6/4/18	0.00	0.00	QC2 Machining-1		
130	QC	6 pcs		6/4/18	0.00	0.00	QC8 Machining-1		
131	HandFinish	6 pcs		6/4/18	0.00	0.00	HandFinish2		
140	Outsource	6 pcs		6/4/18			ATG001-VC	5	
150	Packaging	6 pcs		6/4/18	0.00	0.00	Packaging2		
155	QC	6 pcs		6/4/18	0.00	0.00	QC5		
180	Packaging	6 pcs		6/4/18	0.00	0.00	Packaging3-1		
190	QC21-SA	6 Ea		6/4/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 10.313"

Descriptions: 110 - 1-Machine per folio FB408

140 - Issue P/O to ATG : 8001064 Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S6.000X0.250	7075-T6S Sheet 6" Thick Plate X 0.25" Wide	5.1540 ft (.859 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S6.000X0.250	5	39	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket A	0.090inches $\pm$ 0.005	0.095 0.085		
2	Bracket A	45.000inches $\pm$ 0.500	45.500 44.500		
3	Bracket A	0.255inches $\pm$ 0.005	0.260 0.250		
4	Bracket A	9.810inches $\pm$ 0.010	9.820		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval					
Description Work Order Deviation			Disposition						
			Completed By _____						
			Supervisor _____						
			Signature _____						
			Date: 06/08/18						
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>			Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐ </td> </tr> </table>			Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐
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OTHER : _____									

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 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaero.com



Container No: S079457



Part: 647.7810

Job No: 178039

Serial No/Batch: S079457

Revision:

Inspector:

Instructions:

			9.800	
5	Bracket A	0.260inches $\pm$ 0.010	0.270 0.250	Radius
6	Bracket A	29.900Degrees $\pm$ 0.500	30.400 29.400	Angle
7	Bracket A	3.671inches $\pm$ 0.005	3.676 3.666	
8	Bracket A	16.900Degrees $\pm$ 0.500	17.400 16.400	Angle
9	Bracket A	9.463inches $\pm$ 0.005	9.468 9.458	
10	Bracket A	100.000Degrees $\pm$ 0.500	100.500 99.500	Angle
11	Bracket A	18.700Degrees $\pm$ 0.500	19.200 18.200	Angle
12	Bracket A	9.092inches $\pm$ 0.002	9.094 9.090	
13	Bracket A	3.332inches $\pm$ 0.002	3.334 3.330	
14	Bracket A	7.300inches $\pm$ 0.002	7.302 7.298	
15	Bracket A	0.397inches $\pm$ 0.002	0.399 0.395	
16	Bracket A	2.575inches $\pm$ 0.002	2.577 2.573	
17	Bracket A	2.475inches $\pm$ 0.002	2.477 2.473	
18	Bracket A	0.500inches $\pm$ 0.002	0.502 0.498	
19	Bracket A	0.400inches $\pm$ 0.002	0.402 0.398	

Plex 5/25/18 10:32 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915388

Date: 14-Jun-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
6 ea	Part: 647.7810 Rev: A Bracket A Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23242 PO: PO040164 Line: 1		
DAS 38 9-89			
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>14/06/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			



A.T.G. Industries Inc.
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Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

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DAS
38
2-89